

Date: Wednesday, 3/7/2007 8:38:11 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUSSET	
Job Number	: 31031C				
Estimate Number	: 10843				
P.O. Number	: N/A		Part Number	: D22495	
This Issue	3/7/2007	S.O. No. : N/A	Drawing Number	: D2249 REV. E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 4/10/2007	
Checked & Approved By			Qty:	20	Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet ml07/04/24
	Comment: Qty.: 0.0243 sf(s)/Unit Total : 0.4860 sf(s) 304/316 .063 Sheet Material: AISI 304/316 SS 0.063" thick (M304S16GA) Batch: m101873	
2.0	SHEAR	SHEAR ml07/04/24
	Comment: SHEAR Cut blank: 1.000" x 1.600"	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 ml07/04/24
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr any rough edges	
4.0	QC5	INSPECT WORK TO CURRENT STEP ml07/04/24
	Comment: INSPECT WORK TO CURRENT STEP	8B 07/04/24
5.0	PACKAGING 1	PACKAGING RESOURCE #1 ml07/04/24
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 21	7/4/26 S 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 31031C

Part Number: D22495

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/07

Job Completion



07/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

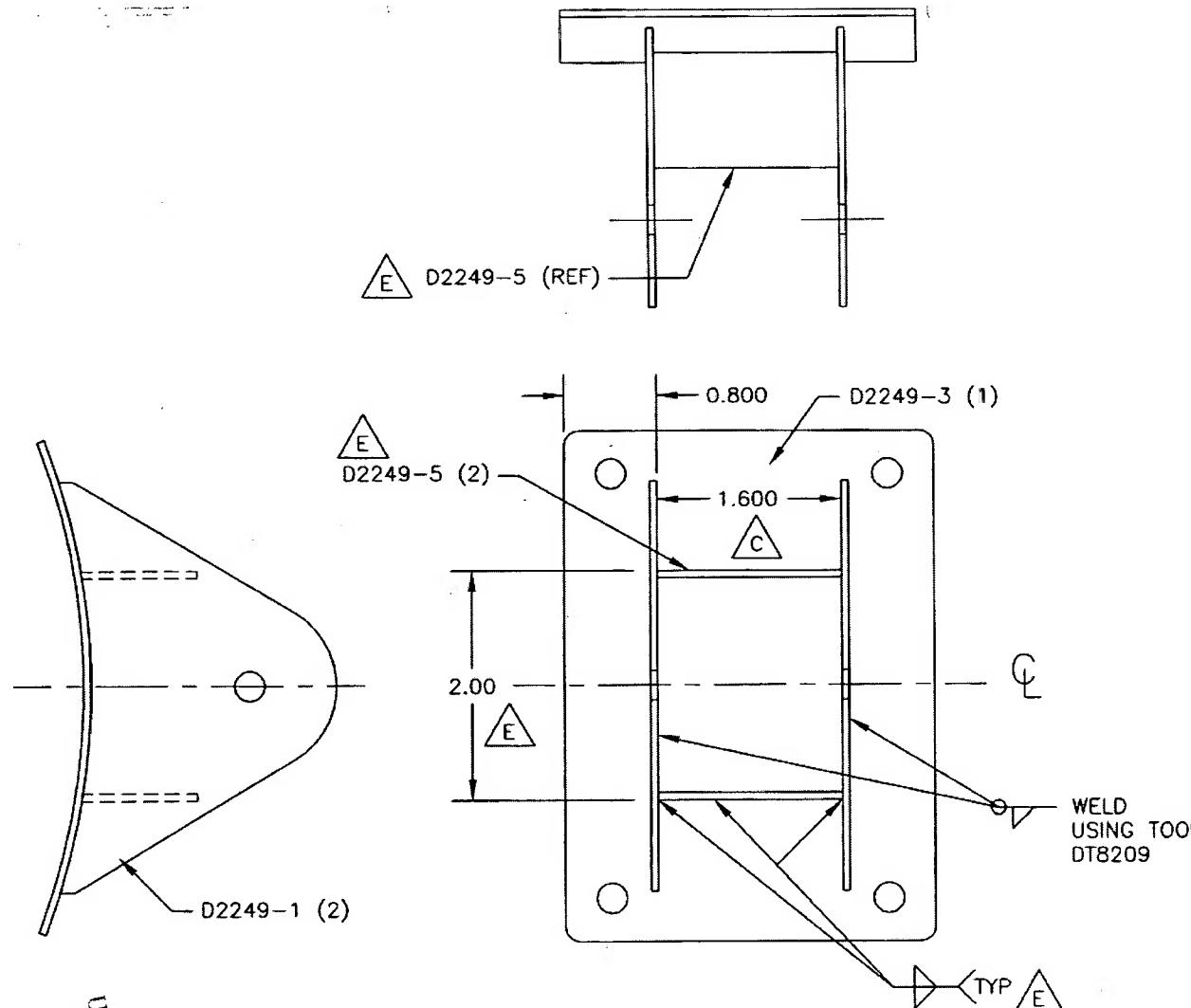
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY  
RIGHTED**RELEASED**99.10.12  
KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KE	APPROVED H	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A 94.06.20	NEW ISSUE		
B 95.11.30	DIMENSION CHANGE		
C 95.12.14			
D 98.04.30	$\phi 0.261$ WAS $\phi 0.257$ (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E 99.09.20	ADDED GUSSET		

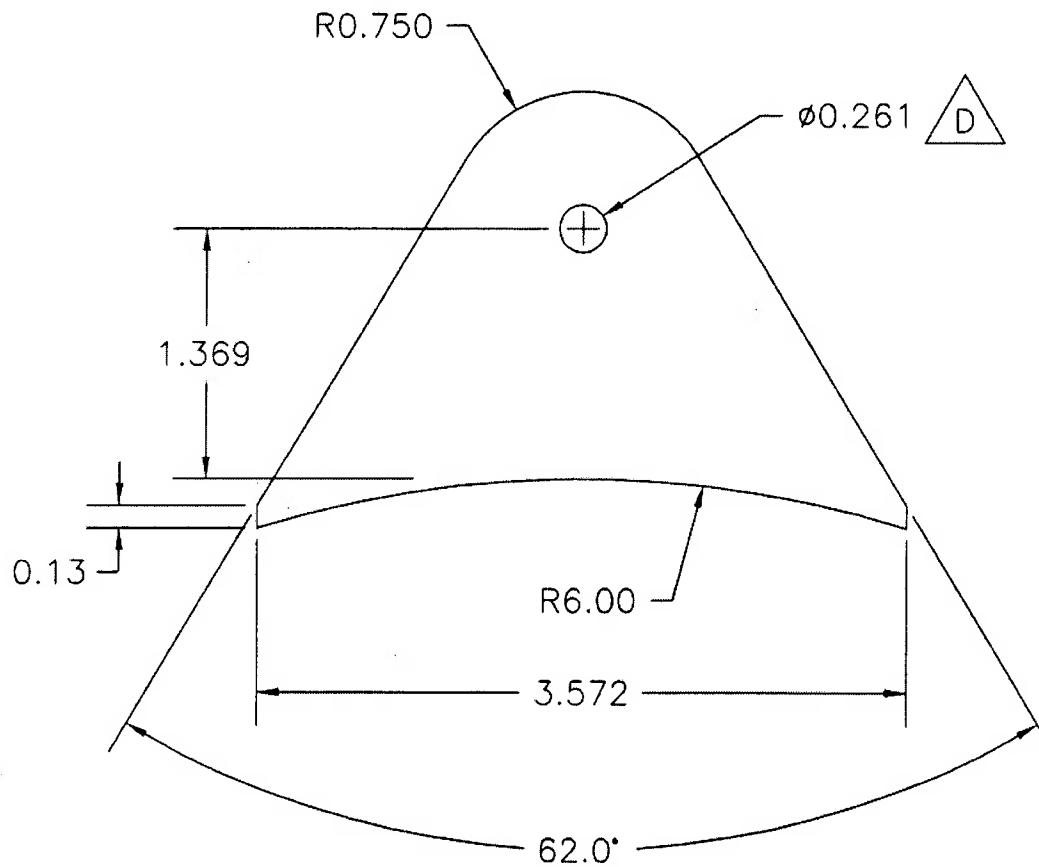
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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WITHOUT NOTICE  
WORK ORDER  
NO. 31031C

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BY

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

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DATE 99.09.20	TITLE FITTING	REV. E SHEET 3 OF 4 1:1

**RELEASED**  
99.10.12 *KE*99.10.12 *KE*

Ø0.261 (TYP)



R0.125 (TYP)

4.44

3.690



2.400

0.375 (TYP)

3.20

0.400 (TYP)

FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

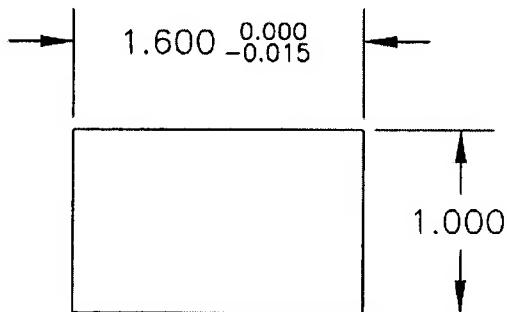
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NO. 31031C  
WORK ORDER

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CHECKED <i>KE</i>	APPROVED <i>W</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

**RELEASED**

49 10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
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